

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003062**Date Inspected:** 01-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China

CWI Name:	An Qing Xian		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No
Weld Procedures Followed:	Yes	No
Verified Joint Fit-up:	Yes	No
Approved WPS:	Yes	No
Delayed / Cancelled:	Yes	No

Bridge No: 34-0006**Component:** Tower / OBG**Summary of Items Observed:****Tower Shop Bay 2**

This Quality Assurance (QA) inspector arrived at ZPMC in Shanghai China for observation of Orthotropic Bridge Girders (OBG) and Self Anchored Suspension (SAS) Bridge. During this QA inspector's observation in Tower Shop bay 2 it was noted that ZPMC was in the process of welding Complete Joint Penetration (CJP) weld joints for tower skin plates. During this QA inspector observation it was noted that component numbers ESD1-SA216 A/K-14 A/B and ESD1-SA294-A/G-12B was in process using the Submerged Arc Welding (SAW) process under WPS-B-T-2221-B-U3c-S. ZPMC had their Certified Welding Inspector An Qing Xian monitoring the welding in this bay of the tower shop. It was observed that Mr. Xian had 3 ZPMC Quality Control (QC) personnel assisting him with the monitoring of welding parameters and progression. Also noted was skin plate ESD1-SA216 A/K 14 A/K was being tack welded by ZPMC welder Yang Lei using the Shielded Metal Arc Welding (SMAW) process in the Flat (1G) position. Upon this QA inspectors arrival the welder had just completed the tack welding process for this component.

Bay 4

During the continued observation by this QA inspector it was noted in bay 4 that ZPMC was welding on diaphragm plate splice for component number WSD1-SA317- 3/4 B, ZPMC CWI Zhao Chen Sun was present within this bay monitoring welding progression and parameters for the Submerged Arc Welding (SAW) process. It was noted that the CWI was monitoring pre-heat and interpass temperatures per the approved WPS. Welding continued throughout this QA inspectors shift.

Bay 7

This QA inspector observed ZPMC in bay 7 performing in process welding and back gouging of web plates for floor beam components. It was noted that ZPMC's CWI Huang Wen-Pang was present during the welding

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

operations in this bay and monitoring welding parameters and in progress progression. Component FB015-011 was in process of being welded for joint 045 using FCAW process. ZPMC welder Hong Shuili was performing this function under WPS-B-Y-2232-Tc-U4b-T. Also noted was fit-up of flange to web plate being tack welded under WPS-B-P-2112-2F-SMAW Mr. Wang-Pang was present during this operation to monitor weld parameters and progression.



Summary of Conversations:

No Pertinent conversations today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Riley, Ken	Quality Assurance Inspector
----------------------	------------	-----------------------------

Reviewed By:	Carreon, Albert	QA Reviewer
---------------------	-----------------	-------------